

Work Order ID 86796

86796

Page 1

July-06-12 2:53:23 PM

Item ID: D3220-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler Assembly

Start Date: 7/06/12

Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/03/12

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					(4)			
D3220	B								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut D3220-2 as per Dwg D3220								
2024 1050	Dwg Rev: B								
	Prog Rev: B								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

B12-7-29

B12-7-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item ID: D3220-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler Assembly
 Start Date: 7/06/12 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 SMB 127.24 0.00	DAS 16 2-8-12	relatiz		4			
130 *130* Small Fab Small Fab	Small Fab Memo 1-Deburr 2-C'sink D3220-2 as per Dwg D3220	0.00 0.00				4			12/07/25
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	DAS 16 2-8-12	relatiz		4			

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Page 3

July-06-12 2:53:23 PM

Item ID: D3220-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Doubler Assembly
 Start Date: 7/06/12 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4	216	12-7-27	
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				4x			ES 6/27/12
170 *170* Small Fab Small Fab	Small Fab Memo Assemble D3220-042 doubler as per Dwg D3220	0.00 0.00				4x			ES 6/27/12

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Page 4

July-06-12 2:53:23 PM

Item ID: D3220-042 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Doubler Assembly
Start Date: 7/06/12 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 8/03/12 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									
190	Identify as per dwg & Stock Location: 177	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

DAS 16 12/14/30

46 242

40 12/17/30

12/17/31

MLJ 12/07/30

W/O:		WORK ORDER CHANGES					
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Picklist Print

July-06-12 2:53:22 PM

Page 1

Work Order ID: 86796
Parent Item: D3220-042
Parent Item Name: Doubler Assembly

Start Date: 7/06/12
Start Qty: 4.00

Required Date: 8/03/12
Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-11-06 JLM
IPP: B 06.11.15 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050 2024-T3 .050 sheet		Purchased	No			100	sf	253.5000	0.6926	2.9162104	31	7/12-7-04	

Location	Loc Qty	Loc Code
MAT022	253.5	
117684	22.8	
121216	89.2	
121889	141.5	

MS20426AD3-3 Rivet		Purchased	No			170	Each	2,885.0000	8	32			
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Location	Loc Qty	Loc Code
ST316	2885	
119109	537	
121011	1931	
19099	417	

MS21059L4 Nutplate		Purchased	No			170	Each	48.0000	4	16			
-----------------------	--	-----------	----	--	--	-----	------	---------	---	----	--	--	--

Location	Loc Qty	Loc Code
ST301	8	
117887	3	
119623	5	
ST302	40	
121060	40	

Handwritten notes and signatures:

- ④
- 121889
- 32
- 32
- 15
- M22441
- ⑫

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

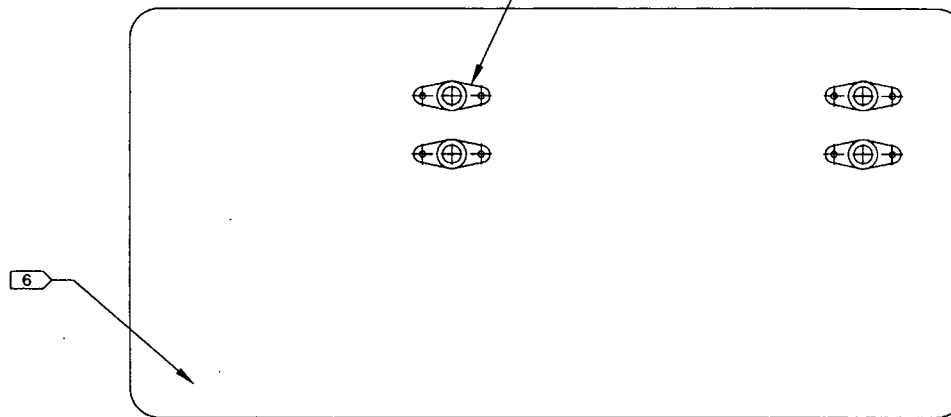
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Item	Qty -041	Qty -042	Part Number	Description
1	X		D3220-041	DOUBLER ASSEMBLY
2		X	D3220-042	DOUBLER ASSEMBLY
3	1		D3220-1	DOUBLER
4		1	D3220-2	DOUBLER
5	4	4	MS21059L4	NUTPLATE
6	8	8	MS20426AD3-3	RIVET

B
MS21059L4 NUTPLATE
MS20426AD3-3 RIVET, 2X
4 PL



D3220-1/2 DOUBLER

**D3220-041 DOUBLER ASSEMBLY (SHOWN WITH D3220-1 DOUBLER)
D3220-042 (OPPOSITE)**





SHOP COPY
RETURN TO:
ENGINEER
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86796

pl 12-07-9

RELEASED
2009-09-09

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3220-041 = 0.53 lbs
D3220-042 = 0.53 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS. Ø0.316 WAS Ø0.323 (ZN C8-2, B4-3); MS20426AD3-3 WAS MS20426AD3-4 (ZN D4-1); CORRECT TYPO NOTE 1 (ZN A8-2, A8-3); REF PAR 09-025	RF	09.07.08
A	NEW ISSUE	CP	03.10.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3220 REV. B SHEET 1 OF 4 TITLE DOUBLER SCALE NTS COPYRIGHT © 2003 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.07.08		

Dart Aerospace Ltd

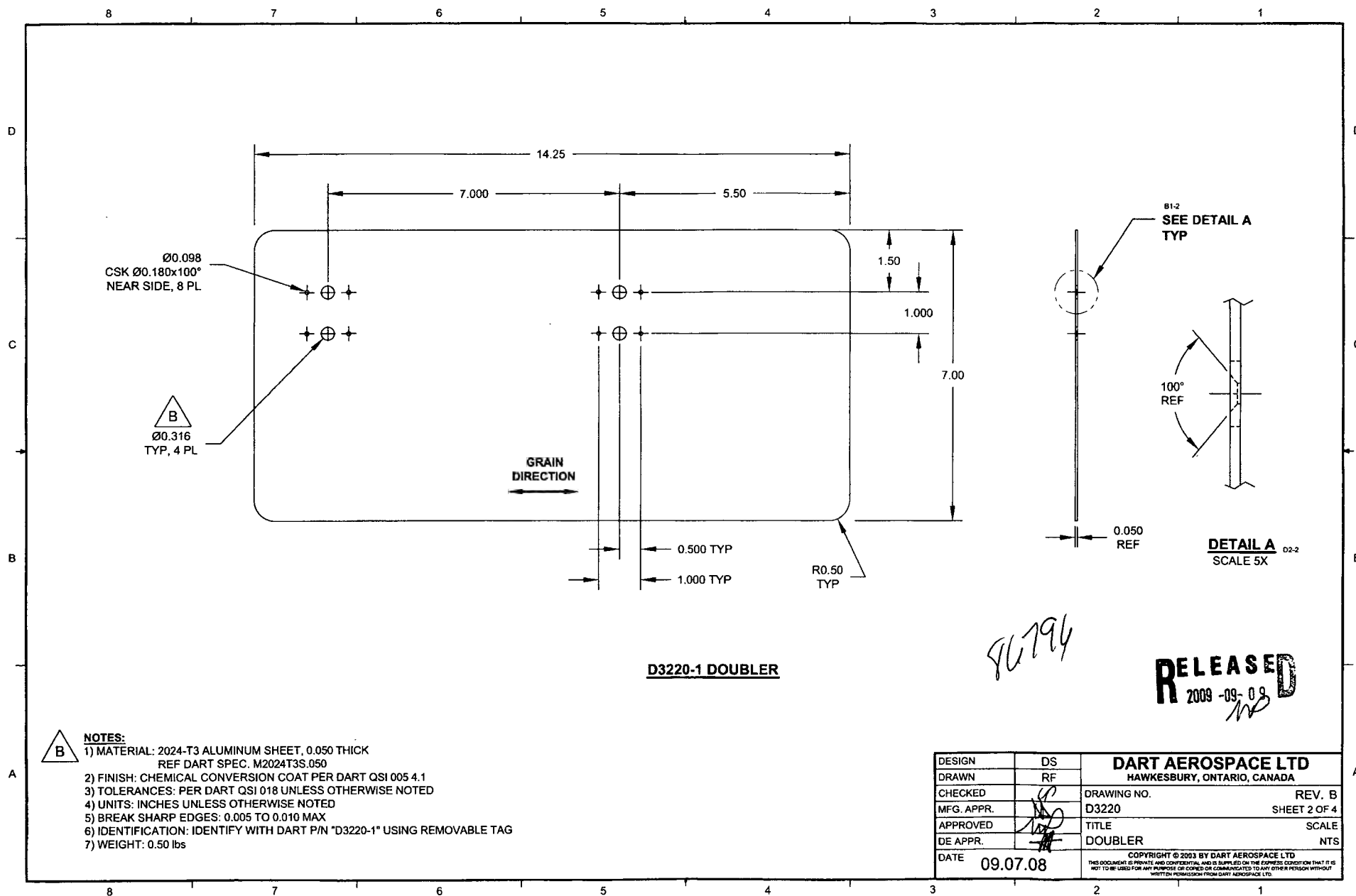
W/O:		WORK ORDER CHANGES					
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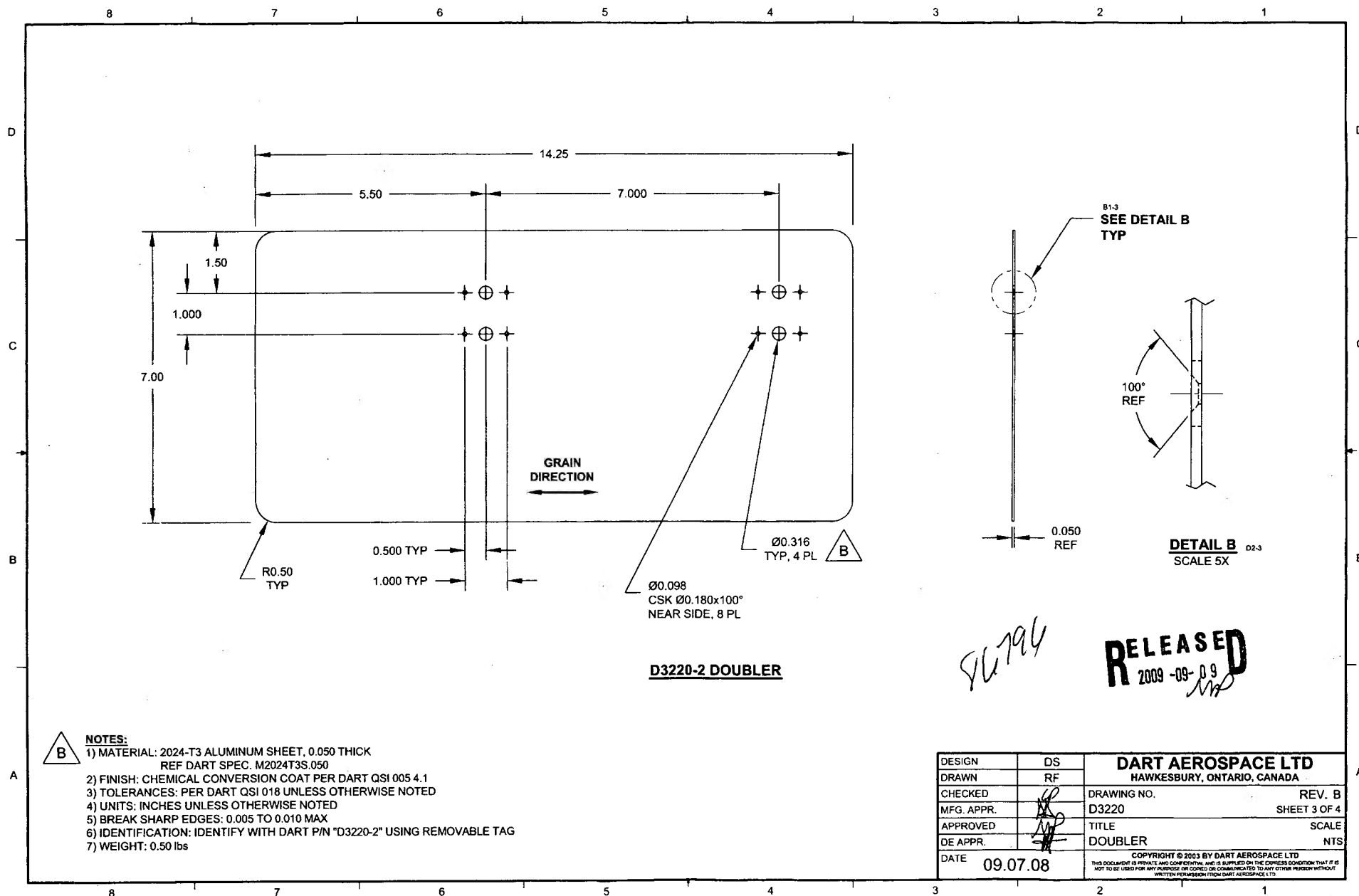
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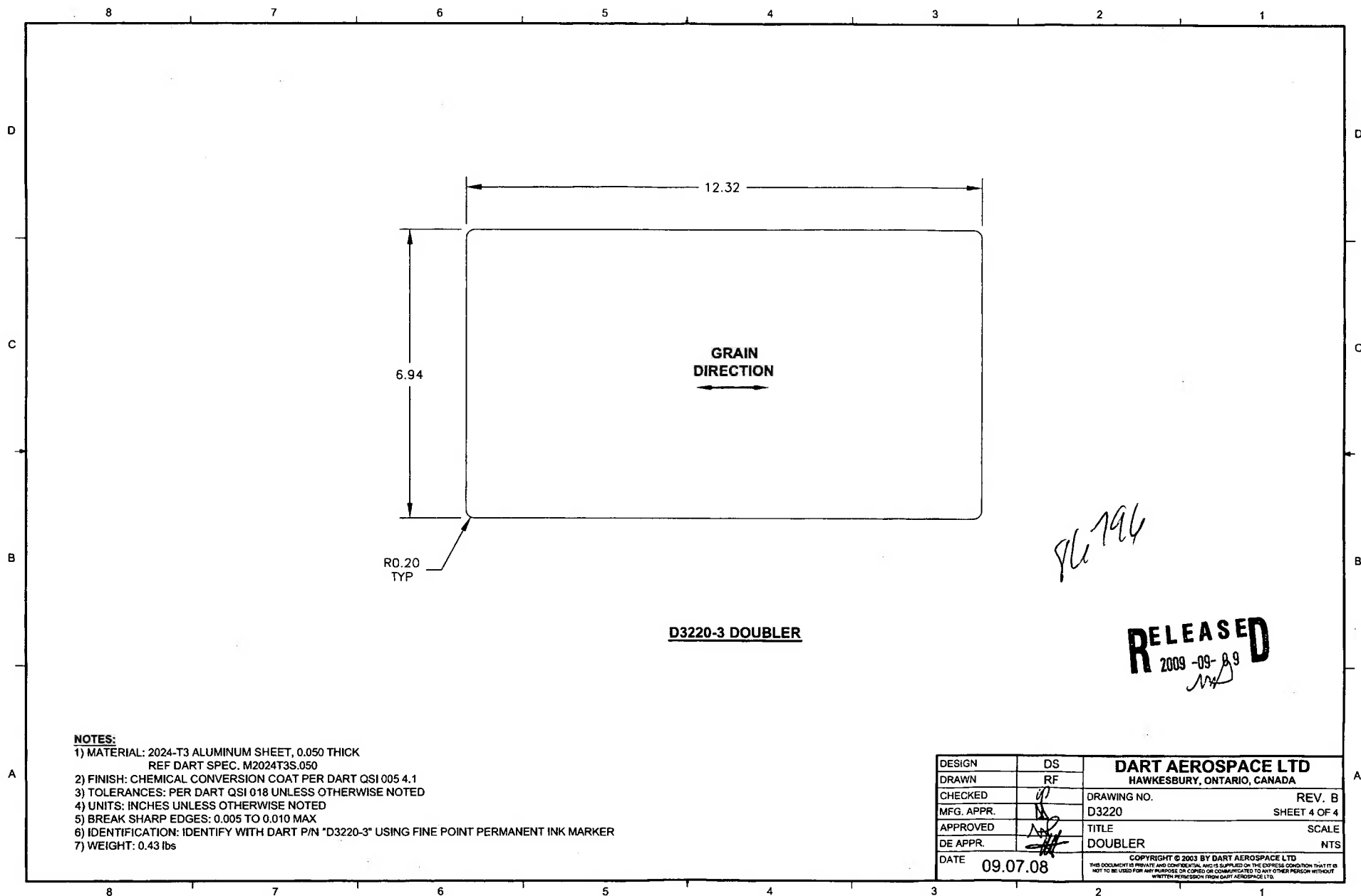
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NOTE: Date & initial all entries



D3220-3 DOUBLER

RELEASED
2009-09-09

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
REF DART SPEC. M2024T3S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.43 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	JP	D3220	SHEET 4 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	DOUBLER	NTS
DATE	09.07.08	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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